

Date:
User:Thursday, 2/9/2006 1:38:26 PM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASSEMBLY
Job Number :	25755A		
Estimate Number :	10206		
P.O. Number :	N/A	Part Number :	D2989041
This Issue :	2/9/2006	Drawing Number :	D2989 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	B
Previous Run :	25614A	Material :	N/A
	Type : LARGE FAB ASSY	Due Date :	2/28/2006
Written By :	SEE COMMENT BELOW		
Checked & Approved By :	KJ 06.02.10		
Comment :	Est Rev:1 Removed D2989-043 05-11-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: B25396

PD

06-02-27

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2581 Mounting Brackets B2539

PD

06-02-27

3.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2327-3 Bushing B24874

PD

06-02-27

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2506 Label Plate B24875

PD

06-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:38:26 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 25755A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number Description Batch

15sf M304EX0.75-16F Expanded Metal

M1000271

PD

06-02-27

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M100038

PD

06-02-27

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

PD

06-03-02

8.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/03/02

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

06/03/04

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M19040

Wing Walk: M10037

06/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/03/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 25755A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



060308

Comment: Inspect Powder Coat and Wing Walk

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/09

Job Completion



06-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19 H

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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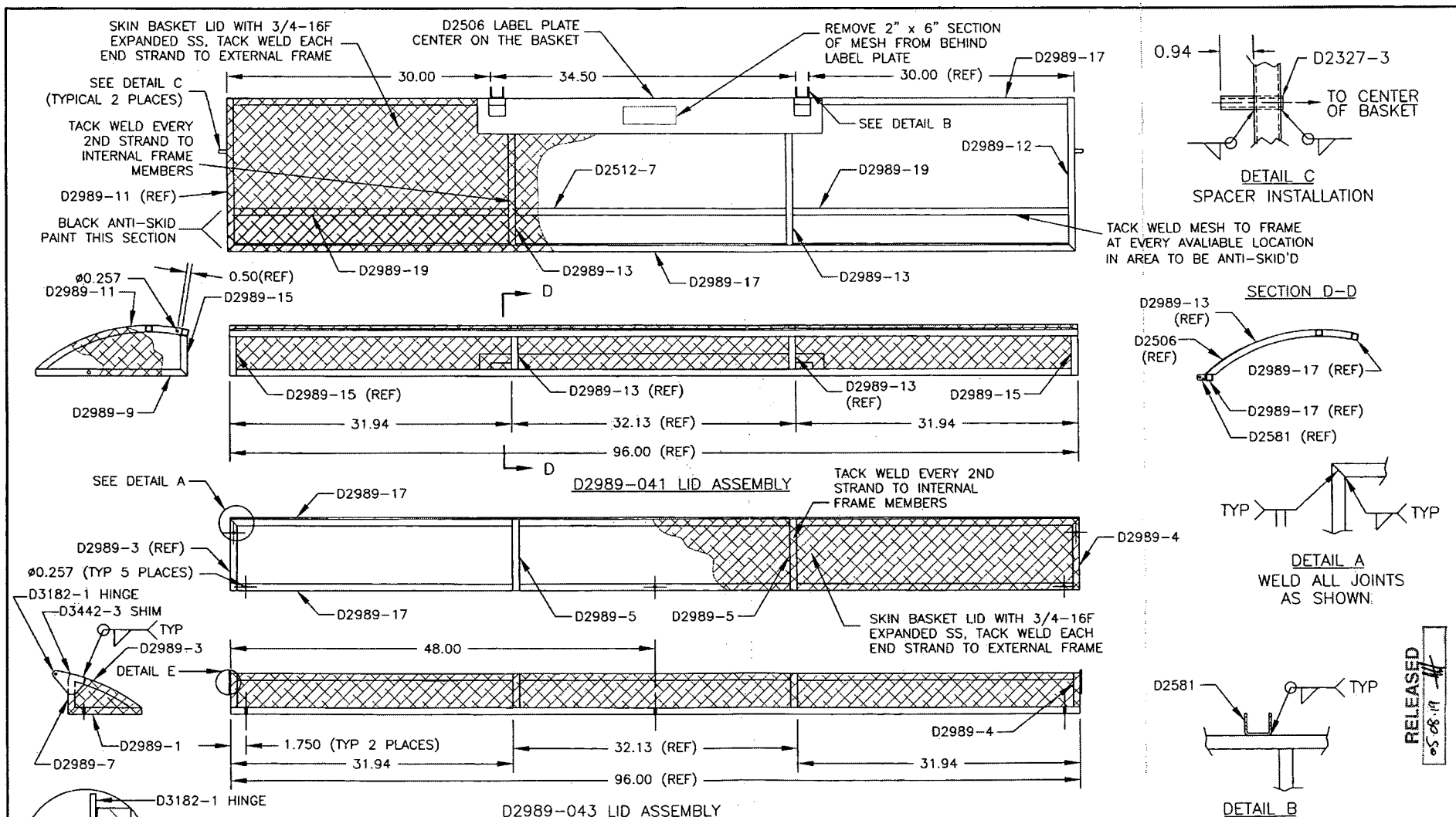
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WORK ORDER

NO. 25755A

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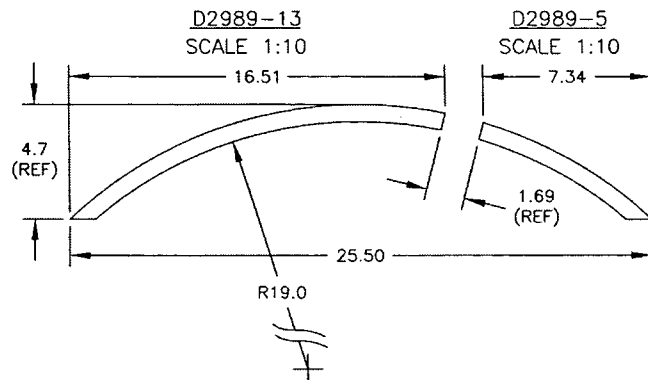
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DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SHEET 2 OF 3	
				SCALE 1:10	

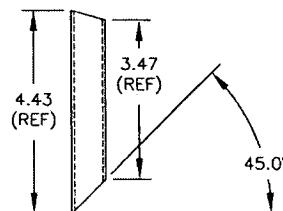
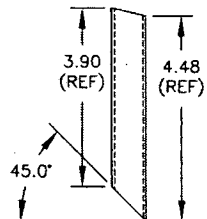
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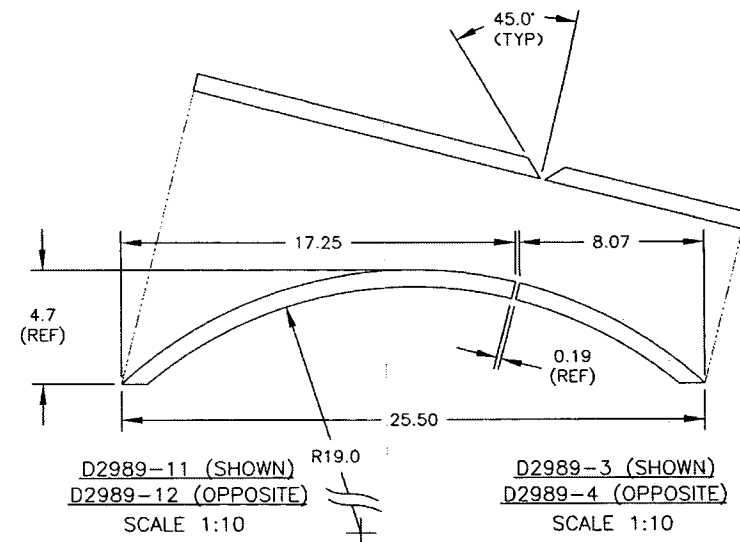
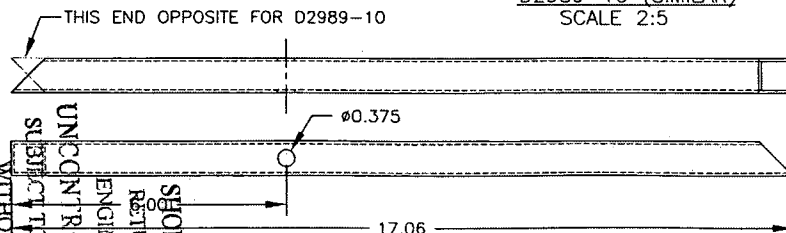


D2989-15
SCALE 2:5
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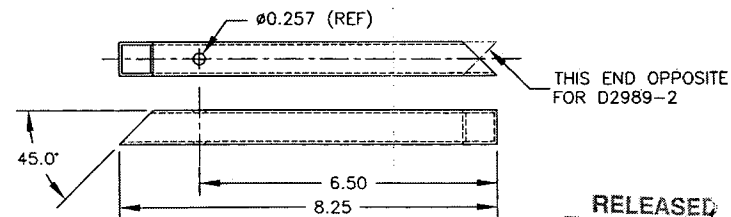
D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



D2989-1 (SHOWN)
D2989-2 (OPPOSITE)
SCALE 2:5



RELEASED
05.08.19

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DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SCALE 1:10	

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